

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-014965**Date Inspected:** 25-May-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Yang**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Orthotropic Box Girder(OBG)**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance (QA) Inspector Manoj Prabhune was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

This QA Inspector randomly observed the following work in progress:

OBG # TRIAL ASSEMBLY YARD

OBG Trial Assembly Yard (Lift 7 West)

The QA inspector performed inspection for the Floor Beam Flange welded at Longitudinal Diaphragm for the Radius and Distance from the Flange to the Weld termination at E3 Location from Panel Point (PP) 48 to PP 61.5, East and West side of Floor Beam.

Report forwarded to team leader for further action, kindly refer to the pictures attached below when measured with 25mm Radius template and 50mm Radius template.

Segment 8CW ~ 8BW

This QA inspector observed ZPMC qualified welding personnel identified as 045213 perform Shielded Metal Arc Welding (SMAW), weld joint identified as DP645-001-021 and was observed welding in the 3G (Vertical) position; ZPMC QC is identified as Mr.Zhang Hai Tao. The welding parameters measured using QC's calibrated

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instrument appeared to be in general compliance with WPS-B-T-3213-B-U3b. See the attached below Photo.

Segment # 9AE ~ 9BE

This QA inspector observed ZPMC qualified welding personnel identified as 068917 perform Shielded Metal Arc Welding (SMAW), weld joint identified as OBE9B-004 and was observed welding in the 4G (Overhead) position; ZPMC QC is identified as Mr. Wang Li Yang. The welding parameters measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-P-2214-B-U2-FCM-1.

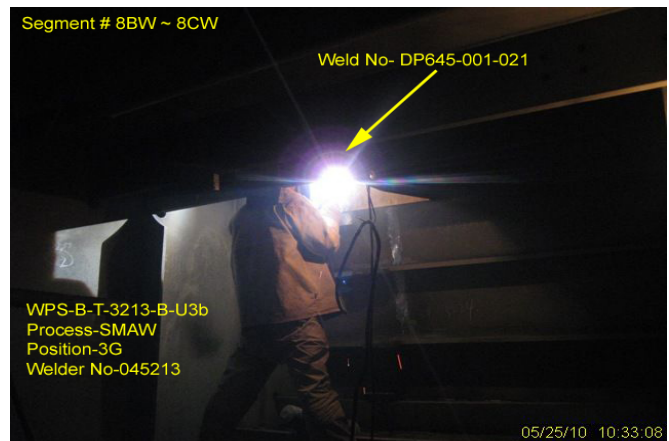
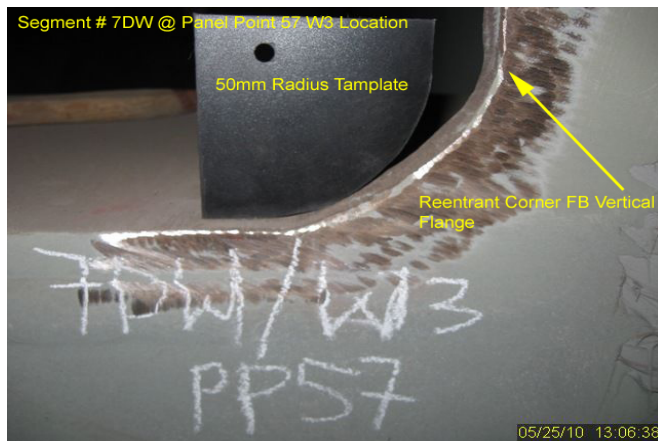
Segment # 9AE ~ 9BE

This QA inspector observed ZPMC qualified welding personnel identified as 069841 perform Shielded Metal Arc Welding (SMAW), weld joint identified as OBE9B-003 and was observed welding in the 4G (Overhead) position; ZPMC QC is identified as Mr. Wang Li Yang. The welding parameters measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-P-2214-B-U2-FCM-1.

Segment # 8CW

This QA inspector observed ZPMC qualified welding personnel identified as 037840 perform Shielded Metal Arc Welding (SMAW), weld joint identified as SEG047B-030 and was observed welding in the 4G (Overhead) position; ZPMC QC is identified as Mr. Zhang Hai Tao. The welding parameters measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-P-2214-TC-U4b-FCM-1.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang phone: 15000422372, who represents the Office of Structural Materials

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for your project.

Inspected By:	Prabhune,Manoj	Quality Assurance Inspector
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Reviewed By:	Patterson,Rodney	QA Reviewer
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